

Work Order ID 164537

Thursday, July 20, 2017 1:20:22 PM

164537

Page 1

Item ID: D3943-3 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Handle Extension
Start Date: 7/31/2017 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 8/3/2017 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan:  Date: JUL 20 2017 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3943	E

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3943

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

0.46

(2)

φ

02/17/07/20

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.02

(2)

φ

02/17/07/20

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125 *125* Mill Conv Conventional Milling Machine	Memo MILL DIMPLE USING 3/8" BALL MANUALLY	0.00 0.17				2	Ø		DAS 32 9-89 17-07-25
130 *130* HAAS 1 HAAS CNC vertical machine #1	Memo MILL AS PER DWG AND FOLIO FA915 FOLIO REV: <u>HA</u> DWG REV: <u>E</u> 2-MILL DIMPLE USING 3/8" BALL MANUALLY	0.30 0.24				2	Ø		DAS 1 9-89 17-08-08
131 *131* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				2	Ø		DAS 1 9-89 17-08-08

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 Item Name: Handle Extension
 Start Date: 7/31/2017 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/3/2017 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.04		<i>D. 17-08-08</i>		<u>2</u>	<u>0</u>		DAS 08 9-89
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u><i>WA002</i></u> Memo LOCATION: WA002	0.00 0.02				<u>2x</u>			DAS 6 89 AUG 0 9 2017
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.20							DAS 21 9-89 AUG 2 1 2017

DAS
21
9-89
AUG 0 9 2017

Picklist Print

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Parent Item: D3943-3

D3943-3

Parent Item Name: Handle Extension

Start Date: 7/31/2017

Required Date: 8/3/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: Est Rev:A New Issue 09-06-03 JLM Verified By:EC IPP Rev:B as
per dwg REV.C DD 10.02.22 verified by:EC IPP REV:C 11.08.16 AS
PER REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B0.500X012.000		Purchased				100	f	13.1000	1.26	2.652632			
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M304B0 500X012 000

**

07/17/20

304 BAR .500 X 12.00

Location

Loc Qty

Loc Code

MAT051

13.1

116061

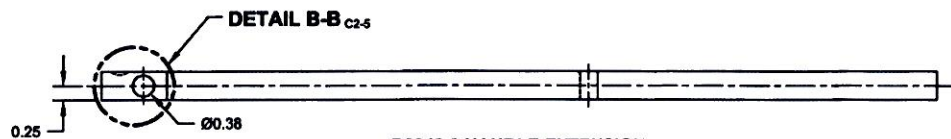
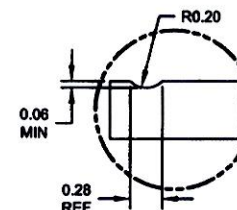
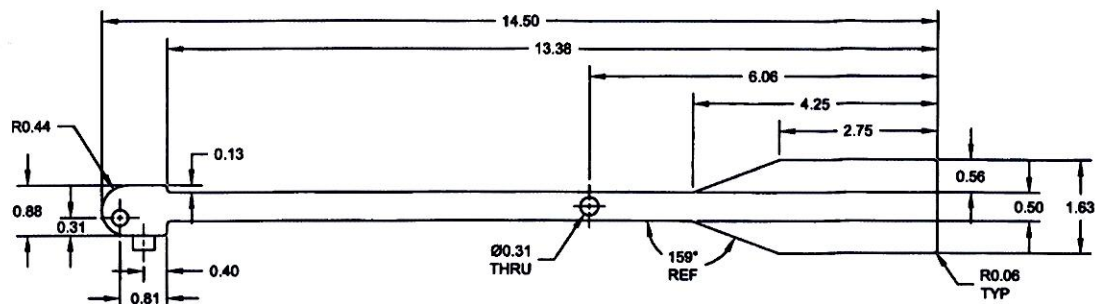
1.1

m137572

12

1

8 7 6 5 4 3 2 1



D3943-3 HANDLE EXTENSION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMEND
WITHOUT NOTICE
WORK ORDER
NO. 164531A
JUL 20 2017

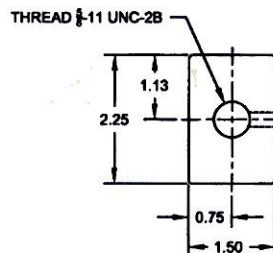
NOTES:

1) MATERIAL -3: AISI 304/316 STAINLESS STEEL SHEET
ANNEALED 2B FINISH PER MIL-S-5059
OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S
OR:
AISI 303 STAINLESS STEEL SHEET
ANNEALED 2B FINISH PER MIL-S-5059
ASTM A240 OR ASME SA240
REF DART SPEC M303S

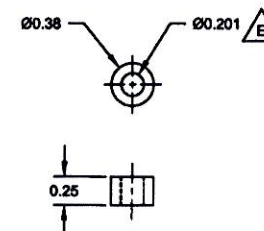
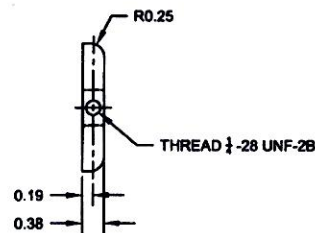
-5: MILD STEEL, SHEET
AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-S
OR:
MILD STEEL, BAR
AISI 1010-1025 OR ASTM A36/A366/A569/A570
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-B

-7: MILD STEEL, ROUND BAR
AISI 1018-1025
PER MIL-S-7097
REF DART SPEC M1018-R

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A



D3943-5 PLATE



D3943-7 STUD
(SCALE 2X)

RELEASED
2011-07-28

DESIGN	DSTOW / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV.
CHECKED	ASS	D3943	SHEET 5 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		GROSS WEIGHT TOW CRANK ASSY	NTS
DE APPR.	N/A	DATE 11.07.27	
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8 7 6 5 4 3 2 1